

Date: Wednesday, 03/06/2009 10:48:48 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)	
Job Number :	48355	Part Number :	D2574	
Estimate Number :	10534	Drawing Number :	D2574 REV E	
P.O. Number :		Project Number :	N/A	
This Issue :	03/06/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	E	
First Issue :	//	Type :	MACHINED PARTS	
Previous Run :	47567	Material :		
Written By :		Due Date :	30/06/2009	Qty: 8 Um: Each
Checked & Approved By :	<u>JLD 09.06.03</u>			
Comment :	Est Rev: I As Per RevE 06-01-27 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D6101005	Saddle Billet
-----	----------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: B46411

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 48355 Double check by: MVF

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

M.A 09/06/07

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

09/06/11
09/06/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 09/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:49 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 48355

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/06/11

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

PK 09-06-11

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:30pm

MF

09-06-15

(XF)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 09/06/15

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 434

9/6/16

(8X)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/17

Job Completion



mf 09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 4835
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		0.441	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	8.001	8.002		
F	0.490	0.510		0.500	0.500	0.494	0.498		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.502	0.502	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.573	0.570	0.570	0.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.128	0.128	0.128	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.230	3.230	3.231		
V	0.230	0.250		0.238	0.238	0.238	0.240		
W	0.115	0.135		0.135	0.135	0.135	0.135		
X	0.307	0.312		0.310	0.310	0.310	0.309		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.362	0.362	0.363	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.628	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.245	0.245		
AE	1.500	1.520		1.5125	1.512	1.513	1.513		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.272	0.272	0.272	0.272		
AH	0.240	0.260		0.249	0.249	0.247	0.247		
AI	2.000	2.020		2.003	2.003	2.004	2.003		
AJ	0.023	0.043							
Accept/Reject									

Measured by: B. A
Date: 09/06/07

Audited by: [Signature]
Date: 09/06/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 48355
Description: Saddle, Aft Inboard		Part Number: D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

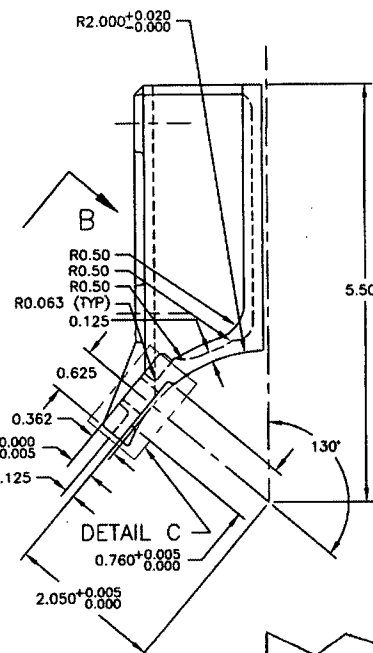
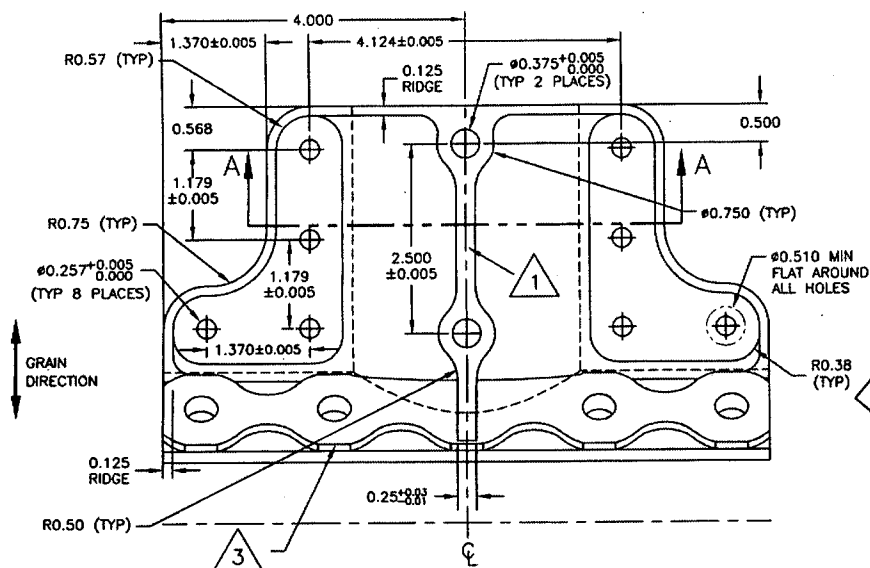
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.001	8.001		
F	0.490	0.510		0.500	0.499	0.495	0.498		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.570	0.570	0.570	0.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.127	0.127	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.231	3.231	3.231		
V	0.230	0.250		0.238	0.238	0.238	0.238		
W	0.115	0.135		0.135	0.135	0.134	0.135		
X	0.307	0.312		0.309	0.312	0.312	0.312		
Y	0.760	0.765		0.761	0.760	0.761	0.760		
Z	0.352	0.372		0.362	0.362	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.245	0.245		
AE	1.500	1.520		1.513	1.5134	1.5134	1.5136		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.272	0.272	0.272	0.272		
AH	0.240	0.260		0.247	0.247	0.247	0.247		
AI	2.000	2.020		2.003	2.0032	2.0032	2.0034		
AJ	0.023	0.043							
Accept/Reject									

Measured by: <u>G. A</u>	Audited by: <u>9ml</u>
Date: <u>09/06/08</u>	Date: <u>09/06/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

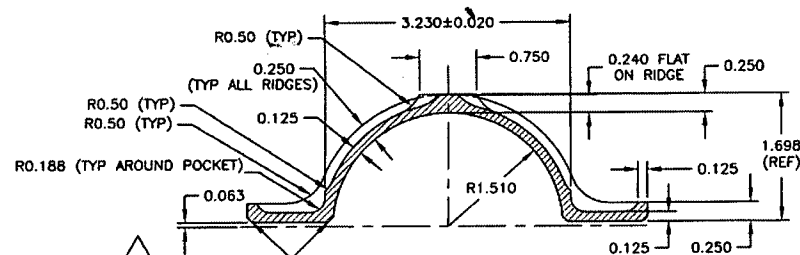
05.12.06 *[Signature]*



NOTES

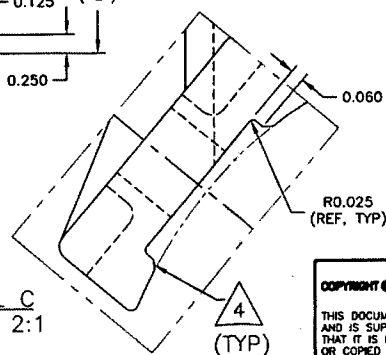
MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

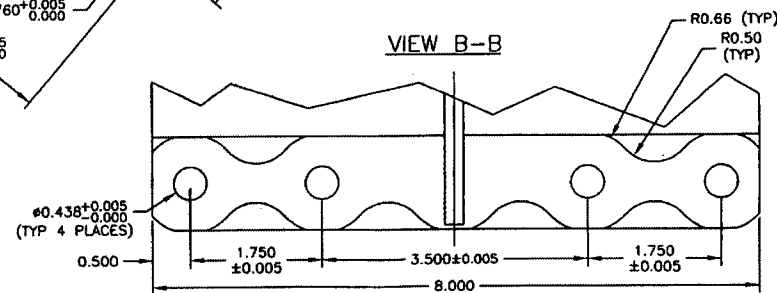


SECTION A-A




SECTION
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48085



DETAIL C
SCALE 2:1



VIEW B-B

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.43B WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN		DRAWN BY	
DS		PH	
CHECKED 		APPROVED 	
DATE		TITLE	
05.07.13		INNER AFT SADDLE	
		 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
		REV.	
		SHEET 1 OF	
		SCALE	
		2:	